

78595

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

20

Cust Item ID:

20

Customer:

Reference:

Run Start *NR1*

Stop ***NR2***

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78595

Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

20

Cust Item ID:

20

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

130 Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

140	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00
-----	--	------

0.00

140

Powdercoat

Memo

0.00

Powder Coating

START TIME:

2625 FINISH TIME:

OVEN TEMPERATURE:

320° F

150	QC3- Inspect Part Finish	0.00
-----	--------------------------	------

0.00

150

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78595

78595

Page 3

January-11-12 2:43:30 PM

Item ID: D3500-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle
 Start Date: 11/01/2012 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 25/01/2012 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <i>CP3</i>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

012-03-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January-11-12 2:43:34 PM

Page 1

Work Order ID: 78595

78595

Parent Item: D3500-1

D3500-1

Parent Item Name: Saddle

Start Date: 11/01/2012

Required Date: 25/01/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 06-06-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6102-013		Manufactured	No			100	Each	12.0000	1	20			

D6102-013

**

Saddle Billet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT043	12	
59467	3	
60713	8	
61300	1	

B77781 X 10
B80931 X 4

mt 12/03/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	78595
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		.487	.487	.487	.487		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.375	.375	.375	.375		
F	0.490	0.510		.500	.500	.500	.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.588	1.588	1.589	1.588		
J	0.240	0.260		.245	.244	.245	.244		
K	0.490	0.510		.500	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.317	.317	.317	.317		
N	0.256	0.262		.260	.260	.260	.260		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.550	.551	.550	.550		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.052	.051		
Y	0.100	0.120		.110	.110	.108	.110		
AA	R1.125	R1.145		1.132	1.133	1.134	1.133		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.253	.252	.253	.251		
AE	1.810	1.830		1.821	1.820	1.820	1.820		
AF	0.240	0.260		.251	.250	.250	.251		
AG	0.140	0.160		.151	.150	.150	.150		
AH	0.140	0.160		.155	.155	.156	.155		
AI	0.140	0.160		.155	.155	.156	.155		
Accept/Reject									

Measured by:	<i>ML</i>
Date:	12/03/23

Audited by:	<i>ST</i>
Date:	12/03/28

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	<i>AA</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	78595
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500		Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	16	17	18	By	Date
A	0.483	0.490		.487	.487	.487	.487		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.375	.375	.375	.375		
F	0.490	0.510		.500	.500	.500	.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.588	1.589	1.589	1.589		
J	0.240	0.260		.244	.244	.244	.245		
K	0.490	0.510		.500	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.317	.317	.317	.317		
N	0.256	0.262		.260	.260	.260	.260		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.550	.550	.550	.550		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.133	1.133	1.134	1.133		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.251	.251	.251	.251		
AE	1.810	1.830		1.820	1.820	1.821	1.821		
AF	0.240	0.260		.250	.251	.251	.250		
AG	0.140	0.160		.152	.151	.151	.151		
AH	0.140	0.160		.155	.154	.153	.155		
AI	0.140	0.160		.155	.155	.156	.155		
Accept/Reject									

Measured by:	am
Date:	12/03/23

Audited by:	SL
Date:	12/03/28

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	AA

DART AEROSPACE LTD		Work Order:	78595
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	Y9	Z10	X11	X12	By	Date
A	0.483	0.490		.487	.487	0.486	0.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.375	.375	0.375	0.375		
F	0.490	0.510		.500	.500	0.500	0.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.587	1.587	1.588	1.589		
J	0.240	0.260		0.247	0.248	0.248	0.249		
K	0.490	0.510		.500	.500	0.500	0.500		
L	3.590	3.650		3.620	3.620	3.620	3.670		
M	0.315	0.322		.317	.317	0.316	0.316		
N	0.256	0.262		.260	.260	0.258	0.258		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.550	0.550	0.550	0.550		
V	0.793	0.803		.798	.798	0.798	0.798		
W	R.240	R.260		.250	.250	0.250	0.250		
X	0.040	0.060		0.050	0.050	0.050	0.050		
Y	0.100	0.120		0.106	0.106	0.106	0.106		
AA	R1.125	R1.145		1.133	1.133	1.134	1.134		
AB	R.490	R.510		.500	.500	0.500	0.500		
AC	0.615	0.635		.635	.635	0.635	0.635		
AD	0.240	0.260		0.255	0.255	0.255	0.255		
AE	1.810	1.830		1.821	1.820	1.820	1.820		
AF	0.240	0.260		0.251	0.251	0.251	0.251		
AG	0.140	0.160		.151	.150	0.150	0.150		
AH	0.140	0.160		0.156	0.154	0.153	0.155		
AI	0.140	0.160		0.157	0.153	0.155	0.155		
Accept/Reject									

Measured by:	MR / D.A.
Date:	12/03/23 / 12/03/24

Audited by:	SL
Date:	12/03/28

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	AA

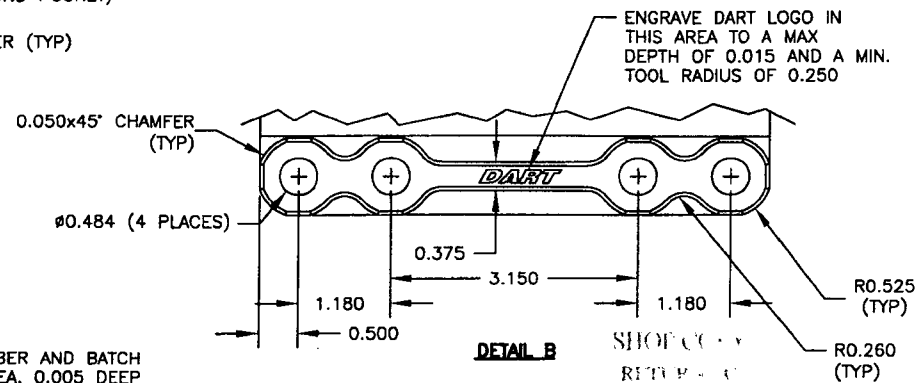
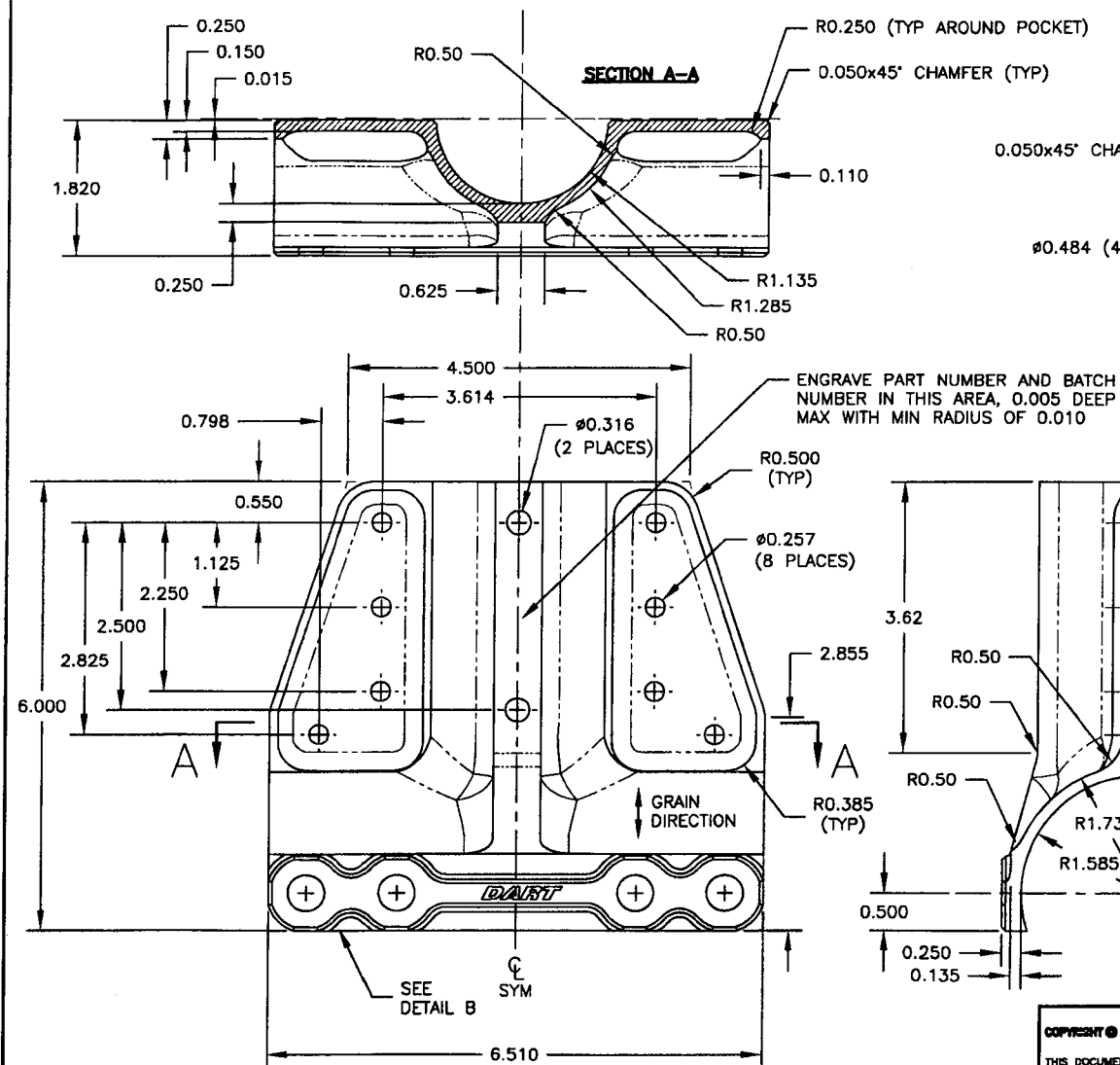
DART AEROSPACE LTD		Work Order:	78595
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500		Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	13	2/4	7	4	By	Date
A	0.483	0.490		0.486	0.486				
B	1.175	1.185		1.180	1.180				
C	3.145	3.155		3.150	3.150				
D	1.175	1.185		1.180	1.180				
E	0.365	0.385		0.375	0.375				
F	0.490	0.510		0.500	0.500				
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.589	1.589				
J	0.240	0.260		0.249	0.249				
K	0.490	0.510		0.500	0.500				
L	3.590	3.650		3.620	3.620				
M	0.315	0.322		0.316	0.316				
N	0.256	0.262		0.258	0.258				
O	6.500	6.520		6.510	6.510				
P	5.990	6.010		6.000	6.000				
Q	2.820	2.830		2.825	2.825				
R	2.495	2.505		2.500	2.500				
S	2.245	2.255		2.250	2.250				
T	1.120	1.130		1.125	1.125				
U	0.540	0.560		0.550	0.550				
V	0.793	0.803		0.798	0.798				
W	R.240	R.260		0.250	0.250				
X	0.040	0.060		0.050	0.050				
Y	0.100	0.120		0.106	0.106				
AA	R1.125	R1.145		1.134	1.134				
AB	R.490	R.510		0.500	0.500				
AC	0.615	0.635		0.635	0.635				
AD	0.240	0.260		0.255	0.255				
AE	1.810	1.830		1.825	1.825				
AF	0.240	0.260		0.251	0.251				
AG	0.140	0.160		0.150	0.150				
AH	0.140	0.160		0.153	0.154				
AI	0.140	0.160		0.155	0.155				
Accept/Reject									

Measured by:	B.A.
Date:	12/03/24

Audited by:	Jh
Date:	12/03/24

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	



UNCONTROLLED COPY
SUBJECT TO AMENDMENT

D3500-1 SADDLE

- NO. 78595 12/01/11
- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/11)
(MAKE FROM D6102-013 SADDLE BILLET, 6061)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1,
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES

RELEASED

06.08.15

C	06.06.30	MAT'L NOW 6061-T6/T651
B	06.05.29	CHANGE DIMS; MAT'L NOW 7075-T7351
A	06.04.18	NEW ISSUE
DESIGN	PH	DART
CHECKED	PH	DART
APPROVED	PH	DART
DATE	06.06.30	SADDLE
DRAWING NO.	D3500	REV. C
TITLE	SADDLE	SHEET 1 OF 1
SCALE		2:3

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DART AEROSPACE LTD.
WINDYBURY, ONTARIO, CANADA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries